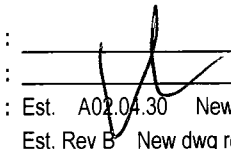


Date: Wednesday, 16/01/2008 9:57:19 AM  
 User: Linda Lacelle

## Process Sheet

|                                    |   |                           |             |
|------------------------------------|---|---------------------------|-------------|
| <b>Customer</b> :                  | CU-DAR001 Dart Helicopters Services   | <b>Drawing Name</b> :     | DOUBLER     |
| <b>Job Number</b> :                | 36731   | <b>Part Number</b> :      | D3140241    |
| <b>Estimate Number</b> :           | 11472   | <b>Drawing Number</b> :   | D3140 REV F |
| <b>P.O. Number</b> :               |   | <b>Project Number</b> :   | N/A         |
| <b>This Issue</b> :                | 16/01/2008  | <b>S.O. No.</b> :         |             |
| <b>Prsht Rev.</b> :                | NC  | <b>Drawing Revision</b> : | F           |
| <b>First Issue</b> :               | //  | <b>Material</b> :         |             |
| <b>Previous Run</b> :              | 36731   | <b>Due Date</b> :         | 31/01/2008  |
| <b>Written By</b> :                |    |                           |             |
| <b>Checked &amp; Approved By</b> : |   |                           |             |
| <b>Comment</b> :                   | Est. A02.04.30 New Issue NG<br>Est. Rev B New dwg rev. ecn781 06.04.18 EC<br>Est Rev:C Now on Waterjet 06-06-08 JLM<br>Est. rev.D added scuffing NCR 061 EC<br>Est Rev:E As per ECN #829 06-11-20 JLM<br>Est Rev:F now on water jet 08-01-15 DD |                           |             |

Qty: 6 Um: Each

## Additional Product

Job Number:



| Seq. #: | Machine Or Operation: | Description : |
|---------|-----------------------|---------------|
|---------|-----------------------|---------------|

|     |             |                  |
|-----|-------------|------------------|
| 1.0 | M2024T3S020 | Alum. sheet .020 |
|-----|-------------|------------------|



**Comment:** Qty.: 1.1321 sf(s)/Unit Total : 6.7927 sf(s)

Alum. sheet .020

Matl: 2024-T3 ( QQ-A-250/4 ) .020" thick

( M2024T3S.020 )

Batch MJ1622 B 8-1-18

|     |           |                |
|-----|-----------|----------------|
| 2.0 | WATER JET | FLOW WATER JET |
|-----|-----------|----------------|



**Comment:** FLOW WATER JET

1-Cut as per Dwg D3140

Dwg Rev: E

Prog Rev: E

B 8-1-18

2-Deburr if necessary

B 8-1-18

⑦

|     |     |  |
|-----|-----|--|
| 3.0 | QC2 | INSPECT PARTS AS THEY COME OFF MACHINE |
|-----|-----|--|



**Comment:** INSPECT PARTS AS THEY COME OFF MACHINE

|     |     |              |
|-----|-----|--------------|
| 4.0 | QC8 | SECOND CHECK |
|-----|-----|--------------|



**Comment:** SECOND CHECK

06/01/01

④

| W/O: |      | WORK ORDER CHANGES |    |      |     |                                     |                          |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE   | By | Date | Qty | Approval<br>Chief Eng /<br>Prod Mgr | Approval<br>QC Inspector |
|      |      |                    |    |      |     |                                     |                          |
|      |      |                    |    |      |     |                                     |                          |

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

| NCR: |      | WORK ORDER NON-CONFORMANCE (NCR) |                             |                                 |                |                           |                       |                          |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC<br>Section A   | Corrective Action Section B |                                 |                | Verification<br>Section C | Approval<br>Chief Eng | Approval<br>QC Inspector |
|      |      |                                  | Initial<br>Chief Eng        | Action Description<br>Chief Eng | Sign &<br>Date |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |

NOTE: Date & initial all entries

Date: Wednesday, 16/01/2008 9:57:19 AM  
User: Linda Lacelle

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: DOUBLER

Job Number: 36731

Part Number: D3140241

Job Number:



Seq. #:

Machine Or Operation:

Description :

5.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

1-Scuff surfaces with 80grit sandpaper per QSI 006

2-Deburr if necessary

No sharp edges

Handwritten: 08/01/24 (7) km

6.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

Handwritten: 08/01/25 (x7)

7.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

Handwritten: 08-01-28 (x7)

8.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

Handwritten: 08/01/28 (7)

9.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: 57148

Handwritten: 08/01/28 (7)

10.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

Handwritten: 08/01/30 (7)

Job Completion



Handwritten: 08/01/30

| W/O: |      | WORK ORDER CHANGES |    |      |     |                                     |                          |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE   | By | Date | Qty | Approval<br>Chief Eng /<br>Prod Mgr | Approval<br>QC Inspector |
|      |      |                    |    |      |     |                                     |                          |
|      |      |                    |    |      |     |                                     |                          |

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

| NCR: |      | WORK ORDER NON-CONFORMANCE (NCR) |                             |                                 |                |                           |                       |                          |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC<br>Section A   | Corrective Action Section B |                                 |                | Verification<br>Section C | Approval<br>Chief Eng | Approval<br>QC Inspector |
|      |      |                                  | Initial<br>Chief Eng        | Action Description<br>Chief Eng | Sign &<br>Date |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |

NOTE: Date & initial all entries



**DART**

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| CHECKED<br>JH    | APPROVED<br>#  | DRAWING NO.<br>D3140   | REV. F<br>SHEET 1 OF 7 |
| DATE<br>06.10.06 |                | TITLE<br>DOOR  | SCALE<br>NTS           |
| A                | 02.04.18       | NEW ISSUE  |                        |
| B                | 03.01.23       | REMOVE -65/-81/-83;<br>ADD -301/-303   |                        |
| C                | 04.11.08       | CHANGE DELASTEK SPEC. TEC-77; ADD<br>PART MARKING; ADD NOTES 11, 12, 13;<br>CHANGE ANGLE -95/-97/-98 TO 106° |                        |
| D                | 05.11.23       | ADD -103/-104/-105/-106;<br>REMOVE -67   |                        |
| E                | 06.06.09       | 1.75 WAS 1.88, 4.75 WAS 4.13 ON<br>-08/-07, 1.00 WAS 1.20 ON -09/-10   |                        |
| F                | 06.10.06       | ADD NOTE 14; CORRECT PART TITLE,<br>NOW D3140-09/-92/-104 SHOWN<br>D3140-10/-91/-103 OPPOSITE                |                        |

**RELEASED**

06.11.13

| QTY<br>-05 | QTY<br>-06 | QTY<br>-07 | QTY<br>-08 | QTY<br>-09 | QTY<br>-10 | PART NUMBER  | DESCRIPTION      |
|------------|------------|------------|------------|------------|------------|--------------|------------------|
| X          |            |            |            |            |            | D3140-05     | DOOR             |
|            | X          |            |            |            |            | D3140-06     | DOOR             |
|            |            | X          |            |            |            | D3140-07     | DOOR             |
|            |            |            | X          |            |            | D3140-08     | DOOR             |
|            |            | 1          |            | X          |            | D3140-09     | DOUBLER ASSEMBLY |
|            |            |            | 1          |            | X          | D3140-10     | DOUBLER ASSEMBLY |
| 3          | 3          |            |            |            |            | D3140-57     | PAD              |
| 1          | 1          |            |            |            |            | D3140-59     | PAD              |
| 2          | 2          |            |            |            |            | D3140-61     | PAD              |
| 2          | 2          |            |            |            |            | D3140-63     | PAD              |
|            |            | 1          | 1          |            |            | D3140-69     | PAD              |
|            |            | 1          | 1          |            |            | D3140-71     | PAD              |
|            |            | 1          | 1          |            |            | D3140-73     | PAD              |
|            |            | 1          | 1          |            |            | D3140-75     | PAD              |
|            |            | 1          | 1          |            |            | D3140-77     | PAD              |
|            |            | 1          | 1          |            |            | D3140-79     | PAD              |
|            |            |            |            | 1          | 1          | D3140-85     | ANGLE            |
| 1          | 1          |            |            |            |            | D3140-87     | DOUBLER          |
|            |            |            |            | 1          | 1          | D3140-89     | DOUBLER          |
|            |            | 1          |            |            |            | D3140-91     | DOUBLER          |
|            |            |            | 1          |            |            | D3140-92     | DOUBLER          |
| 3          | 3          |            |            |            |            | D3140-95     | DOUBLER          |
| 1          |            |            |            |            |            | D3140-97     | DOUBLER          |
|            | 1          |            |            |            |            | D3140-98     | DOUBLER          |
|            |            | 1          | 1          |            |            | D3140-99     | DOUBLER          |
|            |            | 2          | 2          |            |            | D3140-101    | DOUBLER          |
|            |            | 1          |            |            |            | D3140-103    | DOUBLER          |
|            |            |            | 1          |            |            | D3140-104    | DOUBLER          |
|            |            | 1          |            |            |            | D3140-105    | DOUBLER          |
|            |            |            | 1          |            |            | D3140-106    | DOUBLER          |
| 1          | 1          |            |            |            |            | D3140-241    | DOUBLER          |
| 1          |            | 1          |            |            |            | D3140-301    | DOUBLER          |
|            | 1          |            | 1          |            |            | D3140-303    | DOUBLER          |
|            |            |            |            | 5          | 5          | MS20426AD3-4 | RIVET            |

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| CHECKED<br>Jh    | APPROVED<br>#  | DRAWING NO.<br>D3140                              | REV. F<br>SHEET 2 OF 7 |
| DATE<br>06.10.06 |                | TITLE<br>DOOR                                     | SCALE<br>NTS           |

1

COMPOSITE LAYUP & BONDING I.A.W. DELASTEK PROCESS SPEC. TEC-77  
MATERIAL STORAGE & HANDLING TO BE I.A.W. DART QSI 006  
MAIN LAYUP USES FIBERCOTE E-761/7781 EPOXY FIBERGLASS.  
FILL WITH EPOCAST 87269 OR MAGNOBOND 77 A & B AND MA560 FOAM/ NB-51/30 FOAM

2

FINISH: DUPONT HIGHBUILD GREY PRIMER 1144-S

3

MAKE PARTS IN ACCORDANCE WITH THE FOLLOWING TOOLS/MOLDS:

| PART      | TOOL          |
|-----------|---------------|
| D3140-05  | B30-23000-01T |
| D3140-06  | B30-23000-02T |
| D3140-07  | B30-23000-03T |
| D3140-08  | B30-23000-04T |
| D3140-57  | B30-23000-57T |
| D3140-61  | B30-23000-61T |
| D3140-63  | B30-23000-63T |
| D3140-69  | B30-23000-69T |
| D3140-71  | B30-23000-71T |
| D3140-73  | B30-23000-73T |
| D3140-75  | B30-23000-75T |
| D3140-77  | B30-23000-77T |
| D3140-79  | B30-23000-79T |
| D3140-89  | D3140-89T1    |
| D3140-301 | D3140-301T1   |
| D3140-303 | D3140-303T1   |

**RELEASED**

06.11.13

4

MATERIAL: 2024-T3 (QQ-A-250/4) 0.032 THICK (M2024T3S.032)  
FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1

5

MATERIAL: 2024-T3 (QQ-A-250/4) 0.020 THICK (M2024T3S.020)  
FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1

6

MATERIAL: 5052-H32/H34 (QQ-A-250/8) 0.040 THICK (M5052H32S.040)  
FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1

7

MATERIAL: POLIMEX TR75 1" THICK 4.5 LB KLEGECELL

8

ALL DIMENSIONS IN INCHES

9

TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

10

MATERIAL: 6061-T6 (QQ-A-250/11) 0.063 THICK (M6061-T6S.063)  
FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1

11

DOUBLER TO SIT ON TOP OF FOAM AT THIS LOCATION

12

DOUBLER TO BE RECESSED FLUSH INTO FOAM AT THIS LOCATION

13

RUBBER STAMP WITH DART P/N D3140-05/-06/-07/-08 USING MIL-STD-130

14

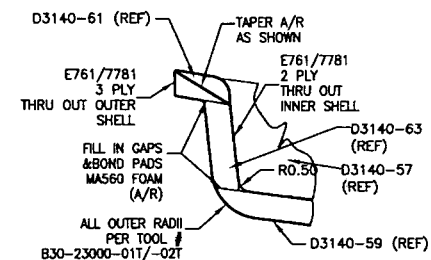
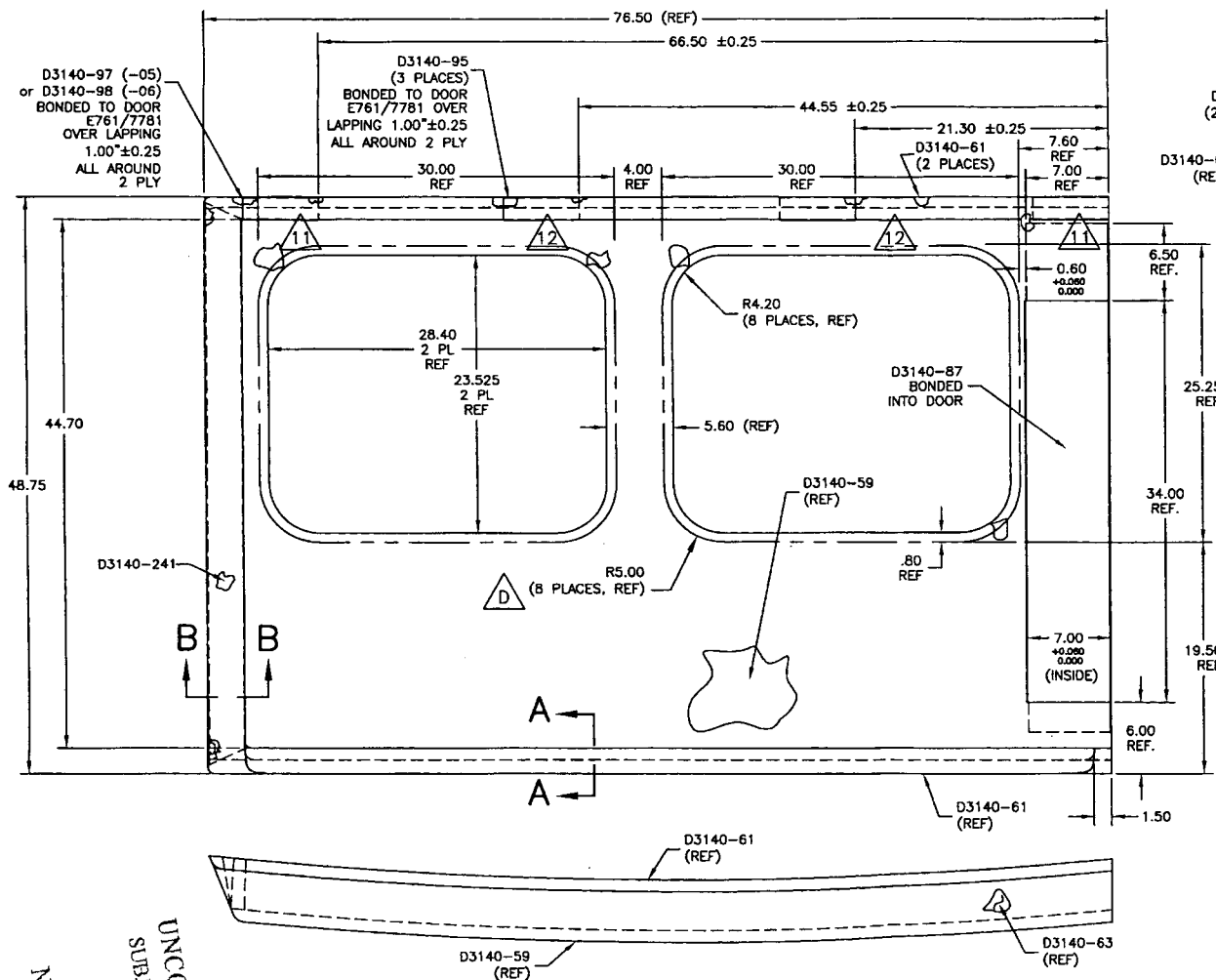
PARTS MUST BE SCUFFED WITH 80 GRIT SANDPAPER PRIOR TO ACID ETCH AND  
ALODINE PER DART QSI 005 4.1

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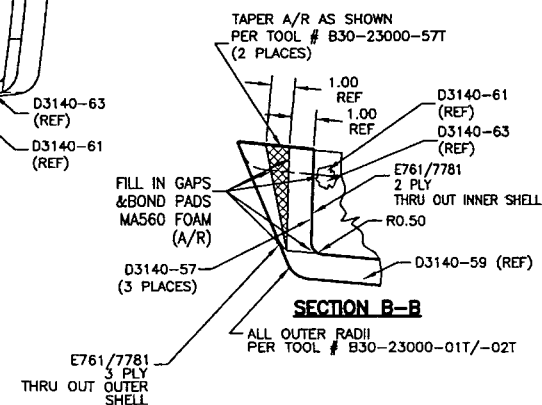
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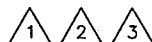


RELEASED

06.11.17



**D3140-05 DOOR (SHOWN, REPLACES PREMIER P/N B30-23000-05)**  
**D3140-06 DOOR (OPPOSITE, REPLACES PREMIER P/N B30-23000-06)**  
 (WINDOWS & CUTOUTS TO BE LOCATED PER B30-23000-01T/-02T TOOL)



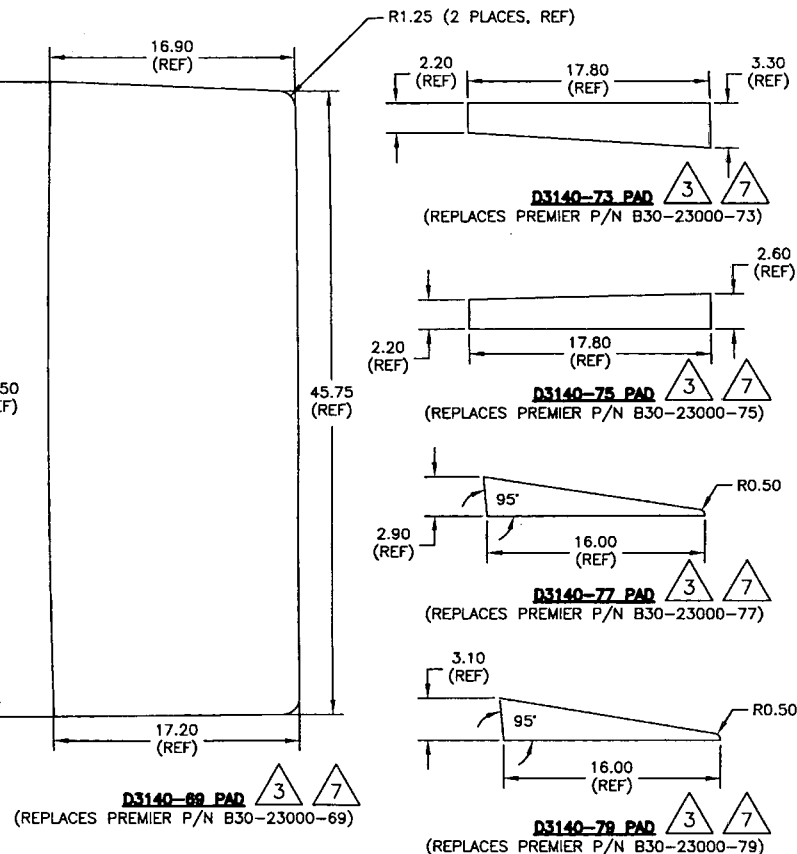
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| DESIGN  | 4        | DRAWN BY | CB   | <b>DART</b> | DART AEROSPACE LTD.<br>HAMPSHIRE, ONTARIO, CANADA |
| CHECKED | dh       | APPROVED | dh   | DRAWING NO. | D3140   |
| DATE    | 06.10.06 | TITLE    | DOOR | REV. F      | SHEET 3 OF 7                                      |
|         |          |          |      | SCALE       | NTS   |





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06.11.13



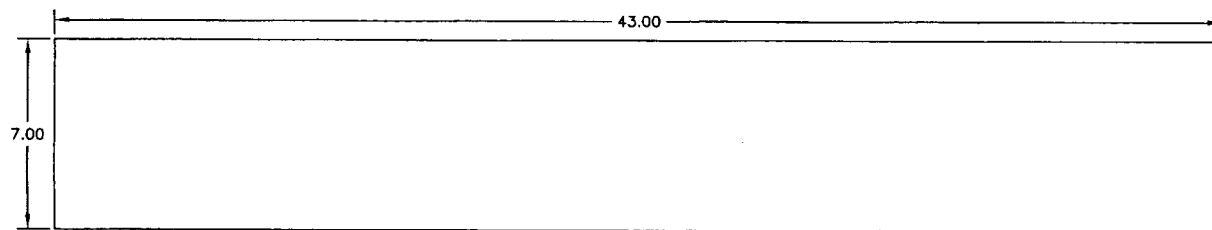
- D3140-103 (SHOWN)  
D3140-104/-105/-106 (SIMILAR)  
DOUBLER EDGE

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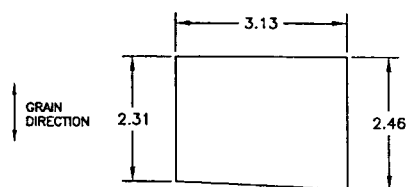
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| CHECKED<br><i>[Signature]</i> | APPROVED<br><i>[Signature]</i> | DRAWING NO.<br>D3140 |  | REV. F<br>SHEET 4 OF 7                                 |  |
| DATE<br>06.10.06              |                                | TITLE<br>DOOR        |  | SCALE<br>NTS   |  |

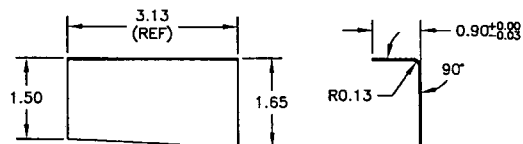




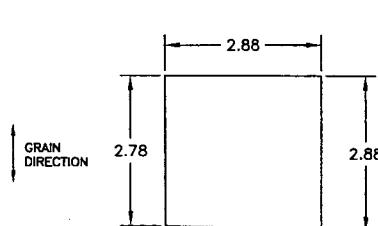
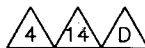
**D3140-87 DOUBLER**   
(REPLACES PREMIER P/N B30-23000-87)



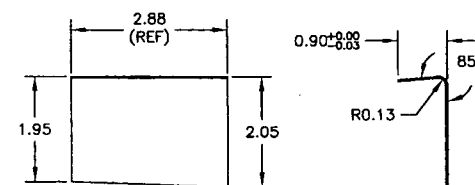
**D3140-105F FLAT PATTERN**  
(USED TO MAKE D3140-105/-106 BRACKETS)



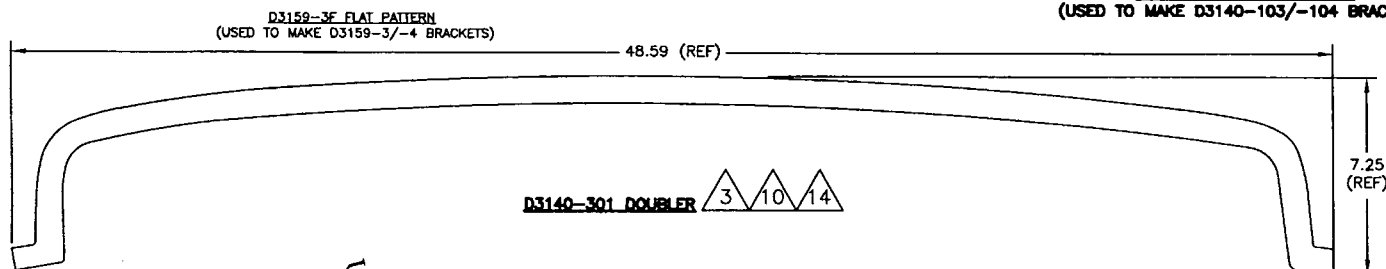
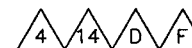
**D3140-105 DOUBLER**  
D3140-108 OPPOSITE



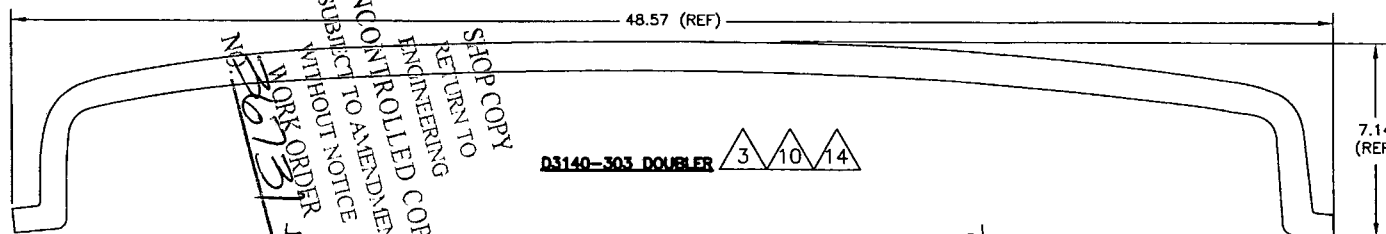
**D3140-103F FLAT PATTERN**  
(USED TO MAKE D3140-103/-104 BRACKETS)



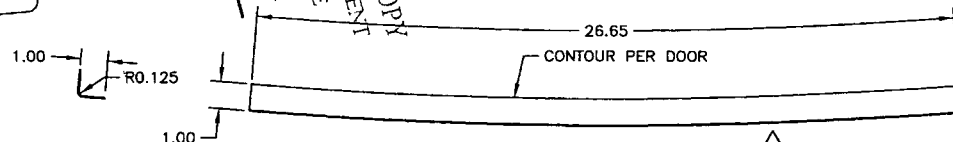
**D3140-104 DOUBLER**  
D3140-103 OPPOSITE



**D3140-301 DOUBLER**



**D3140-303 DOUBLER**



**D3140-85 ANGLE**   
FLAT PATTERN: 26.65" x 1.90"  
(REPLACES PREMIER P/N B30-23000-85)

RELEASED

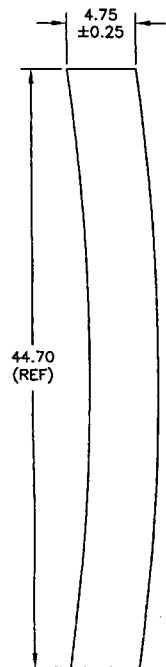
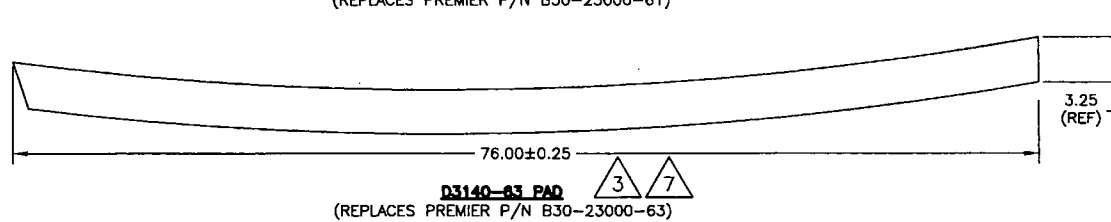
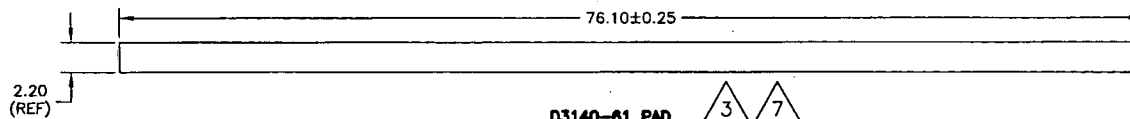
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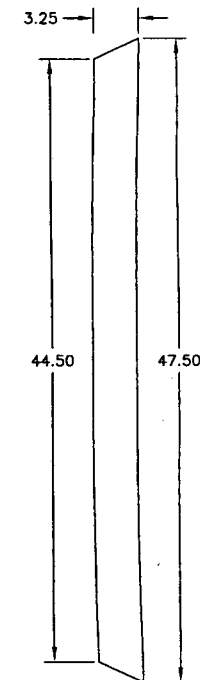
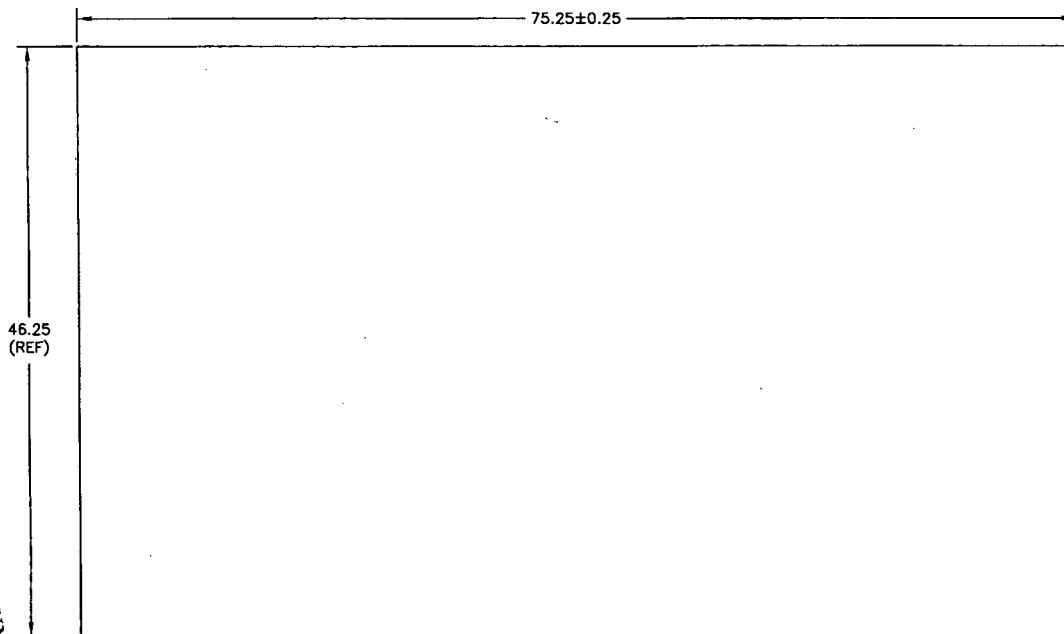
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| CHECKED |          | APPROVED |      | DRAWING NO. | REV. F  |
| DATE    | 06.10.06 | TITLE    | DOOR | D3140       | SHEET 6 OF 7                                    |
|         |          |          |      |             | SCALE   |
|         |          |          |      |             | NTS   |



**D3140-57 PAD**  
(REPLACES PREMIER  
P/N B30-23000-57)  
3 7



**D3140-241 DOUBLER** 5 14  
(REPLACES PREMIER P/N B30-23000-241)

RELEASED

06.11.13

R1.00  
(2 PLACES, REF)

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| DATE    | 06.10.06  |          |           | D3140       | SHEET 7 OF 7                                       |
|         |           |          |           | TITLE       | SCALE  |
|         |           |          |           | DOOR        | NTS  |